

Date: Thursday, 10/11/2007 2:53:32 PM
User: Kim Johnston

Process Sheet

46

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHROUD AIRFLOW HEATER SYSTEM
Job Number	: 35114	Part Number	: D206746011
Estimate Number	: 12345	Drawing Number	: N/A
P.O. Number	: <i>N/A</i>	Project Number	: N/A
This Issue	: 10/11/2007 S.O. No. : <i>N/A</i>	Drawing Revision	: N/A
Prsht Rev.	: NC	Material	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Due Date	: 11/11/2007
Previous Run	: 35113	Qty:	1 Um: Each
Written By	: <i>[Signature]</i>		
Checked & Approved By	: <i>[Signature]</i>		
Comment	: est rev A 06.03.23 new issue EC est rev B 06.04.26 updated pick list EC Est Rev:C 06-05-24 Per Rev A JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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RS 07/10/15

Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-746-011 CHG002

2/12/21

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	35114A	REAR OVERHEAD PASSENGER MODIFICATION KIT
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Comment: Sub-Component REAR OVERHEAD PASSENGER MODIFICATION KIT

D206-746-041 B *35114A*

SC

4.0	35114B	BLOWER MOTOR ASSEMBLY
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Comment: Sub-Component REAR OVERHEAD PASSENGER MODIFICATION KIT

D206-746-043

35114B

6/10/30

5.0	D3467041	SHROUD ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SHROUD ASSEMBLY

Batch: *35114A*

507/12/2007

B34065

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/11/2007 2:53:33 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD AIRFLOW HEATER SYSTEM

Job Number: 35114

Part Number: D206746011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D34681

SEAL



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SEAL

Batch: 1731255 SP

7.0

D34683

LARGE SEAL STRIP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

LARGE SEAL STRIP

Batch: 1734455 SP

8.0

D34685

SEAL



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SEAL

Batch: 1731256 SP

9.0

D3469041

SHUT-OFF VALVE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SHUT-OFF VALVE ASS'Y

Batch: 35110

Co 7/12/11 ①

10.0

D34693

UPPER PLATE BENDING DETAIL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

UPPER PLATE BENDING DETAIL

1734408 SP

11.0

D34715

STIFFENER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STIFFENER

Batch: 1734067 SP

12.0

D3475041

DUMP OUTLET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DUMP OUTLET

Batch: 1734654

7-11-15 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD AIRFLOW HEATER SYSTEM

Job Number: 

Part Number: D206746011

Job Number:



Seq. #: Machine Or Operation: Description :

13.0 D34755 SCREEN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screen

Batch: M28545 SP

14.0 D34757 scoop outlet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

scoop outlet

Batch: M30470 SP

15.0 D34759 OUTLET GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

OUTLET GASKET

Batch: M28546 SP

16.0 D3478041 AIR INLET ADAPTER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

INLET ADAPTER

Batch: M34068 SP

17.0 D34785 SCREEN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SCREEN

batch: M35264 SP

18.0 D34787 INLET GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

INLET GASKET

Batch: 34401 SP

19.0 D34789 INLET SCOOP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

INLET SCOOP

Batch: M332133 SP

7/11/05 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD AIRFLOW HEATER SYSTEM

Job Number: 35114

Part Number: D206746011

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D3481041

Shut off valve bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Shut off valve bracket

Batch: 1735164

SP

21.0

D34821

INLET INSULATION SOCK



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

INLET INSULATION SOCK

Batch: 1724383

SP 1726963

22.0

D34823

OUTLET INSULATION SOCK



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

OUTLET INSULATION SOCK

Batch: 1726966

SP

23.0

D34825

HOSE INSULATION



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

HOSE INSULATION

Batch: 1736967

SP

24.0

D34827

HOSE INSULATION



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HOSE INSULATION

Batch: 1736968

SP 1737845

25.0

D34829

HOSE INSULATION



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

HOSE INSULATION

Batch: 1726969

SP

26.0

D348211

HOSE INSULATION



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

HOSE INSULATION

Batch: 1733987

7-11-15 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD AIRFLOW HEATER SYSTEM

Job Number: 35114

Part Number: D206746011

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D348213

HOSE INSULATION



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

HOSE INSULATION

Batch: 131263 SP 31262

28.0

D34831

DUMP VALVE PLACARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DUMP VALVE PLACARD

29.0

D34833

SHUT-OFF VALVE PLACARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SHUT-OFF VALVE PLACARD

Batch: 131264 SP

30.0

D34835

warning label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DUMP VALVE PLACARD

Batch: 1326471 SP

31.0

31903

BLUE TERMINAL AMP



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BLUE TERMINAL AMP

Batch: 1105442 SP

32.0

AN33A

Bolt



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

33.0

AN35

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

BOLT

Batch: 1108978 7-11-15 SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD AIRFLOW HEATER SYSTEM

Job Number: 35114

Part Number: D206746011

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN9604L

washer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
washer

M101389

SP

35.0

AN9608

WASHER



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
WASHER (A/R)
Batch: *M19359* QTY *10*

SP

36.0

AN96010L

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)
Washer

M101340

SP

37.0

CR322343

Cherry Rivet



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Cherry Rivet
Batch: *M12706*

SB

38.0

DCS549

TURN-TO-LOCK CONTROL



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
PUSH/PULL CONTROL
Batch: *M105926*

SP

39.0

M227591169

16GA ELECTRICAL WIRE, 120" LONG



Comment: Qty.: 10.0000 ft(s)/Unit Total : 10.0000 ft(s)
16GA ELECTRICAL WIRE, 120" LONG
Batch: *M105960*

SP

40.0

MS21083N08

NUT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Qty. (A/R) NUT
Batch: *M100771*

7-11-15 SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/11/2007 2:53:33 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD AIRFLOW HEATER SYSTEM

Job Number: 35114

Part Number: D206746011

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

MS21919DG3

CLAMP



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Qty 10 (A/R) CLAMP

Batch: M100798 *SC*

42.0

MS21919DG44

CLAMP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CLAMP

Batch: M104256 *SC*

43.0

MS21919DG48

CLAMP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CLAMP

Batch: M100798 *SC*

44.0

MS24166D1

RELAY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

RELAY

Batch: M102129 *SC*

45.0

MS2524475

CIRCUIT BREAKER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CIRCUIT BREAKER

Batch: M105419 *SC*

46.0

MS2524415

BREAKER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BREAKER

Batch: M105419 *SC*

47.0

MS270390816

SCREW PAN HD



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Qty 10 (A/R) SCREW PAN HD

Batch: M102171 *7/11/15 SC*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/11/2007 2:53:33 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD AIRFLOW HEATER SYSTEM

Job Number: 35114

Part Number: D206746011

Job Number:



Seq. #:

Machine Or Operation:

Description :

48 0

MS3505822

SWITCH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SWITCH

Batch: M102171

SP

49.0

NAS43DD316N

SPACER



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Qty. 10 (A/R) SPACER

Batch: M104311

SP

50 0

NAS43DD348FC

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch: M105978

SP

51.0

NAS679A3

NUT SELF LOCK



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

NUT SELF LOCK

Batch: M105522

M100631

SP

52.0

QS20044S

CLAMP



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

CLAMP

Batch: M105516

M103947

M105512

SP

53 0

QS20056S

CLAMP



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

CLAMP

Batch: M104236

SP

54.0

SCEET11

SCEET



Comment: Qty.: 12.0000 f(s)/Unit Total : 12.0000 f(s)

SCEET

Batch: M106050

7-11-14 SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DD Date: 07/12/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/11/2007 2:53:33 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD AIRFLOW HEATER SYSTEM

Job Number: 35114

Part Number: D206746011

Job Number:



Seq. #:

Machine Or Operation:

Description :

55.0

SCEET12

HOSE 3" DIAMETER



Comment: Qty.: 11.0000 f(s)/Unit Total: 11.0000 f(s)

HOSE 3" DIAMETER

Batch: 4109078

7-11-B SQ (14)

56.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

4/2/21 (46)

57.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1 Per
PACKAGE PER PPP B

7/12/21 (1X) 50

58.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/07/21 (1)

Job Completion



U 07-12-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

46

Date: Thursday, 10/11/2007 2:53:58 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BLOWER MOTOR ASSEMBLY
Job Number : 35114B	
Estimate Number : 12509	
P.O. Number : <i>NA</i>	Part Number : D206746043
This Issue : 10/11/2007 S.O. No. : <i>NA</i>	Drawing Number : DSI9341
Prsht Rev. : <i>NC</i>	Project Number : <i>N/A</i>
First Issue : <i>NA</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 35113B	Material : <i>NA</i>
Written By : _____	Due Date : 11/11/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : est rev A 06.08.21 New Issue EC	
Est rev B 07.03.15 DSI 9341 Rev B KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D3471041	BLOWER MOTOR SUPPORT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BLOWER MOTOR SUPPORT
Batch: *1534066* *SP*

2.0	D3473041	BLOWER INLET ADAPTER
-----	----------	----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
→ BLOWER INLET ADAPTER
Batch: *B35108* *MF*

3.0	D3476041	blower motor adapter
-----	----------	----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
→ blower motor adapter
Batch: *B34668* *MF*

4.0	D3477041	Blower Motor Inlet Adapter
-----	----------	----------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
K → Blower Motor Inlet Adapter
Batch: *B36432* *MF 07-12-18*

5.0	D35851	SET SCREW
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
SET SCREW *B31384* *7-11-13 SP*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR ASSEMBLY

Job Number: 35114B

Part Number: D206746043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6 0

26D71

Blower Motor



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
JANITROL BLOWER MOTOR ASSEMBLY
Batch: M104032

SP

7 0

AN33A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bolt
Batch: M104547

SP

8 0

AN96010

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Washer
Batch: M1559

7-11-13 SP

(IX)

9 0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Center punch set-screw ,then drill as per dwg.

Assemble as per dwg DSI 9341

Add locktite 26221 to fan set screw batch: m104483

Secure using Lock Wire

A/R MS20995-025E LOCK WIRE

BATCH: m18670

mfa 07-12-19 (1)

10 0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7/12/20 (H)

11 0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-746-043

Location:

PPP Rev: PPP 35114

PC 7/12/20 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DD Date: 07/12/1
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/11/2007 2:53:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR ASSEMBLY

Job Number: 35114B

Part Number: D206746043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



2)

Comment: FINAL INSPECTION/W/O RELEASE

2/07/12/12

Job Completion



W 5/12/11
KK

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>#</i>	DRAWING NO. DSI 9341	REV. B SHEET 1 OF 2
DATE 07.01.02		TITLE BLOWER MOTOR ASSEMBLY SCALE NTS	
REV	DATE	DESCRIPTION	
A	06.08.09	NEW ISSUE	
B	07.01.02	ADD D3585-1 & DETAIL B	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-746 REV.A

REF. CANADIAN STC: SH05-45 ISSUE 1

FAA STC: SH3367NM DATED OCT. 13, 2005

The Parts List of Installation Instructions IIN-D206-746 Rev. A should be amended as follows:

Qty -011	Qty -041	Qty - 043	Part Number	Description
X			D206-746-011	SHROUD AIRFLOW HEATER SYSTEM
1	X		D206-746-041	REAR OVERHEAD PASSENGER MODIFICATION KIT
1		X	D206-746-043	BLOWER MOTOR ASSEMBLY
		1	D3471-041	BLOWER MOTOR SUPPORT (CAM-1984-008)
		1	D3473-041	BLOWER INLET ADAPTER (CAM-1984-013)
		1	D3476-041	BLOWER MOTOR ADAPTER (CAM-1984-014)
		1	D3477-041	BLOWER MOTOR INLET ADAPTER (CAM-1984-015)
<i>B</i>		2	D3585-1	SET SCREW
<i>B</i>		A/R	26221	LOCTITE 226 THREADLOCKER
		1	26D71	BLOWER MOTOR (26D71-1)
		6	AN3-3A	BOLT
		6	AN960-10	WASHER
		3	MS27039-08-04	MACHINE SCREW
		3	MS35333-38	LOCK WASHER
<i>B</i>		A/R	MS20995-025E	LOCK WIRE

Furthermore, any mention of "Blower Motor Assembly" appearing in Installation Instructions IIN-D206-746 Rev. A, and Installation Drawing D206-746 Rev. A, should be replaced by D206-746-043 Blower Motor Assembly.

For assembly instructions of D206-746-043 Blower Motor Assembly, refer to page 2 of this DSI.

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WITHOUT NOTICE
WORK ORDER
NO. *35114B*

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

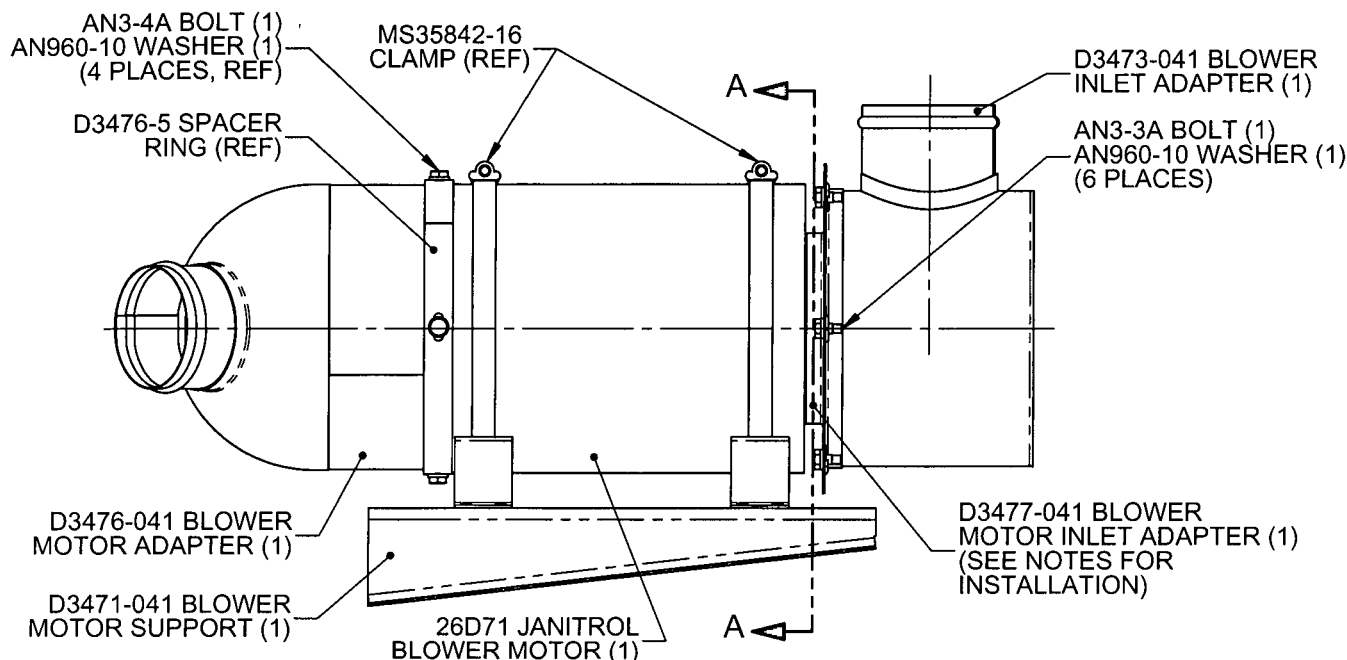
DATE: 07.01.02
CERT. NO.: SH05-45
ISSUE NO.: 1

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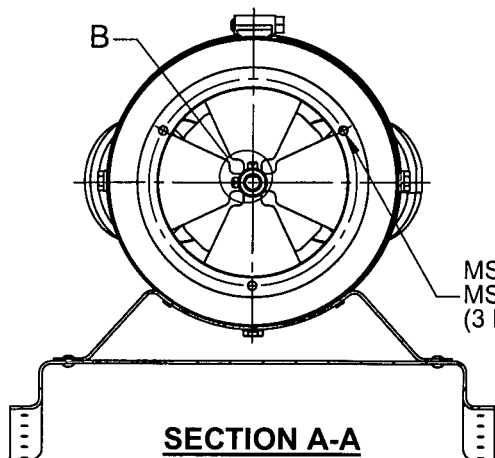
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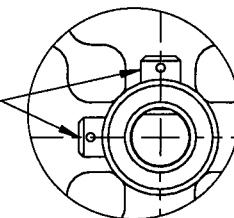
DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. DSI 9341	REV. B SHEET 2 OF 2
DATE 07.01.02		TITLE BLOWER MOTOR ASSEMBLY	SCALE 1:4



D206-746-043 BLOWER MOTOR ASSEMBLY



REPLACE EXISTING SET SCREWS
WITH D3585-1 SET SCREWS (2),
APPLY LOCTITE 226, TORQUE TO
50-70 in-lbs (5.6-7.9 N-m) AND SECURE
USING MS20995-025E LOCK WIRE



DETAIL B
SCALE 1:1

MS27039-08-04 MACHINE SCREW (1)
MS35333-38 LOCK WASHER (1)
(3 PLACES)

NOTES:

- 1) ON 26D71 BLOWER MOTOR, REMOVE EXISTING MACHINE SCREWS (3), LOCK WASHERS (3) AND EXISTING ADAPTER (1).
- 2) REPLACE ADAPTER WITH D3477-041 BLOWER INLET ADAPTER. USE HARDWARE REMOVED AT STEP 1 TO SECURE D3473-041 BLOWER INLET ADAPTER TO 26D71 JANITROL BLOWER MOTOR.
- 3) D206-746-043 IS SUPPLIED TO CUSTOMER PRE-ASSEMBLED.

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CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 07.01.02
CERT. NO.: SH05-45
ISSUE NO.: 1

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Date: Thursday, 10/11/2007 2:53:49 PM
 User: Kim Johnston

Process Sheet

46

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : REAR OVERHEAD PASSENGER MODIFICATION KIT
 Job Number : 35114A
 Estimate Number : 12344
 P.O. Number : N/A Part Number : D206746041
 This Issue : 10/11/2007 S.O. No. : N/A Drawing Number : N/A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL / MED FAB Drawing Revision : N/A
 Previous Run : 35113A Material : N/A
 Due Date : 11/11/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment :
 est rev A 06.03.22 New Issue EC
 est rev B 06.04.26 Updated picklist EC
 Est Rev:C 06-05-24 As Per Rev A JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

10 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-746-041 CHG 001

N/A

20 D3472041 CABIN HEAT OUTLET DEFLECTOR



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description batch
 2 D3472-041 Cabin Heat outlet

734860

SC

30 D34725 FLAT DOUBLER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description batch
 2 D3472-5 Flat doubler

31257

SC

40 D3479041 INLET ADAPTER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description batch
 2 D3479-041 Inlet adapter

735144

SC

7-11-13

SC

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/11/2007 2:53:49 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR OVERHEAD PASSENGER MODIFICATION KIT

Job Number: 35114A

Part Number: D206746041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D3480041

Eyeball Inlet adapter



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description batch
2 D3480-041 eyeball inlet adapter

batch
B34469

sq

6.0

D3480043

Eyeball adapter



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description batch
2 D3480-043 Eyeball adapter

batch
B34071

sq

7.0

D34807

Gasket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description batch
2 D3480-7 Gasket

batch
34072

sq

8.0

99770094

FRESH AIR VENT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description batch
2 9977009-4 Bell eyeball

batch
M105946

sq

9.0

AN34A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description batch
8 AN3-4A Bolt

batch
M103641

7-11-13

sq

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/11/2007 2:53:49 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR OVERHEAD PASSENGER MODIFICATION KIT

Job Number: 35114A

Part Number: D206746041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN96010L

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description

batch

16 AN960-10L Washer

M101340 SP

11.0

CR224842

RIVET



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description

batch

24 CR2248-4-2 Rivet

M105443 SP

12.0

HA000611

CARBON MONOXIDE INDICATOR



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CARBON MONOXIDE INDICATOR

M101042 SP

13.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description

batch

8 MS27039-1-10 Screw

M13883 SP

14.0

NAS1738B42

Blind Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description

batch

12 NAS1738B4-2 Rivet

M105443 SP

15.0

NAS679A3

NUT SELF LOCK



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description

batch

M100651 7-11-13 SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DD Date: 07/12/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/11/2007 2:53:49 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR OVERHEAD PASSENGER MODIFICATION KIT

Job Number: 35114A

Part Number: D206746041

Job Number:



Seq. #:

Machine Or Operation:

Description:

8 NAS679A3 Lock nut

16.0

TY527M

TYRAPS



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description
4 TY-527M Ty raps

batch:

119356

7-11-13 SP (IX)

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5 7/12/21 EL

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-746-041

Location:

PPP Rev:

PPP 35114

7/12/21 @ SP

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1
2007/12/21

Job Completion



2007/12/21
U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries